

Work Order ID 77584

77584

Page 1

Tuesday, December 13, 2011 2:42:58 PM

Item ID: D3805-043 7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly Fwd, High Gear
 Start Date: 12/13/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 1/5/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: Date: 12-13 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3805	B

100		0.00							
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100
 Large Fab
 Large Fab

Memo

1-weld D3806-3 to D3805-3 together as per dwg D3805

304 S.S. Welding Rod

BATCH #: m126048

2059 B Hardcoat welding rod #: m126003 → 2059 b

2-Transfer drill holes in bar

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
-----	--	------	--	--	--	--	--	--	--

110
 QC

Memo

Quality Control

② 212 13-09-06

② 30909 09 09-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							DAS 09 8-89
Quality Control									
130	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 2:10 OVEN TEMPERATURE: 320 FINISH TIME: 2:40	0.00							
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

② BOSOS

2x m/l 13/09/10

2 p 13-9-10

m121274

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 20		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Tuesday, December 13, 2011 2:42:58 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/13/2011 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 1/5/2012 Req'd Qty: 2.00 *?*

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

150

Small Fab

Memo

0.00

Small Fab

1- Bond D3807-3 gasket to inner surface of wearplate using a thin layer of 3m

1300/1300L scotch grip adhesive as per dwg

BATCH: 19124297

0.00

160

QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

170

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 77584***77584***


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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

13/9/11 

13-09-11

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, December 13, 2011 2:43:02 PM

Page 1

Work Order ID: 77584

77584

Parent Item: D3805-043

D3805-043

Parent Item Name: Wearplate Assembly Fwd, High Gear

Start Date: 12/13/2011

Required Date: 1/5/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevB: add transfer drill wearplate to bar DD 09.11.05 ver:EC IPP Rev:C
11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3805-3 *D3805-3* Plate		Manufactured	No				Each	4.0000	**	2		12/13/05	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>4</div> <div></div> </div>													
<div> <div>77440</div> <div>4</div> <div></div> </div>													
D3806-3 *D3806-3* Bar		Manufactured	No				Each	4.0000	**	2		12/13/05	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>2</div> <div></div> </div>													
<div> <div>77511</div> <div>2</div> <div></div> </div>													
<div> <div>WA030</div> <div>2</div> <div></div> </div>													
<div> <div>74654</div> <div>2</div> <div></div> </div>													
D3807-3 *D3807-3* Gasket		Manufactured	No				Each	19.0000	**	2		12/13/11	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>FP002</div> <div>19</div> <div></div> </div>													
<div> <div>58572</div> <div>11</div> <div></div> </div>													
<div> <div>74655</div> <div>8</div> <div></div> </div>													

B 103290 x 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

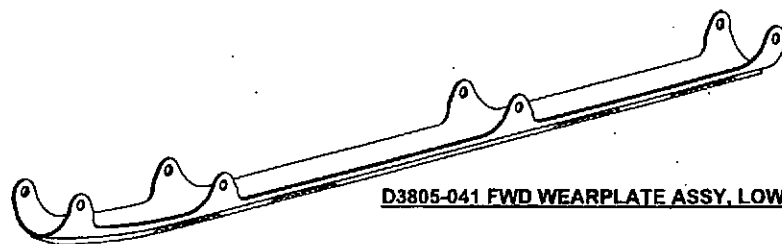
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

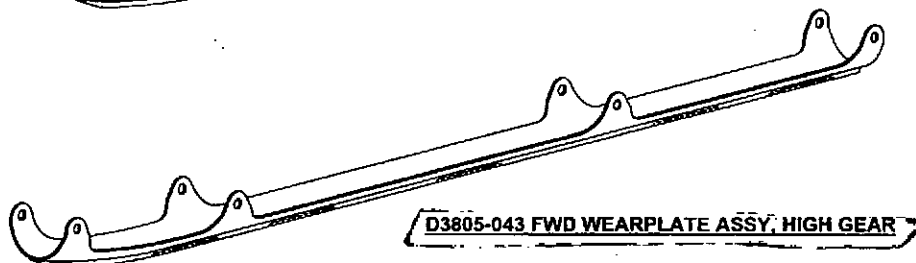
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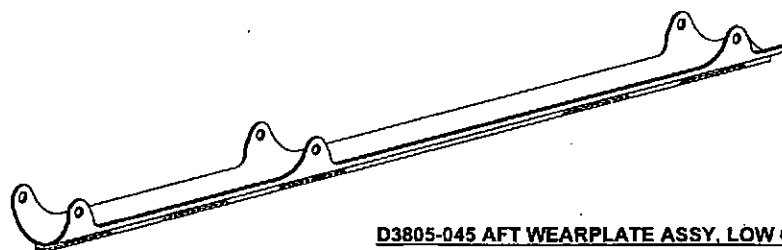
8 7 6 5 4



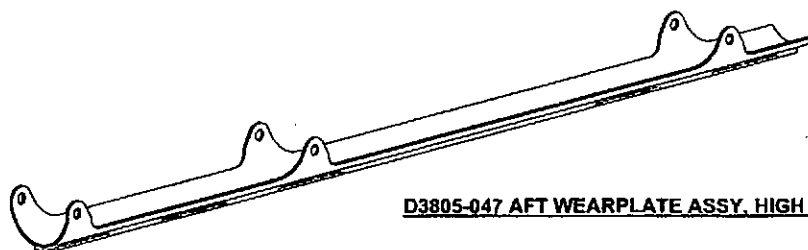
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

8 7 6 5 4

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	20598	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHIN 1 YEAR
WORK IN PROGRESS
NO. 77589

RELEASED
2011-10-03

11-12-13

B	REVISED D3805-1F33F TO EASE MANUFACTURABILITY (ADDED CUT-OUT AT FWD END OF PLATE PER PART 11-106) AND RE-ORGANIZED NOTES SHEETS 2 & 3	MB	11.09.16
A	NEW ISSUE	MB	06.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	11.09.16	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS REPRODUCED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
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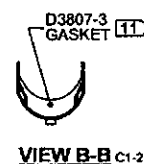
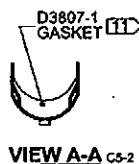
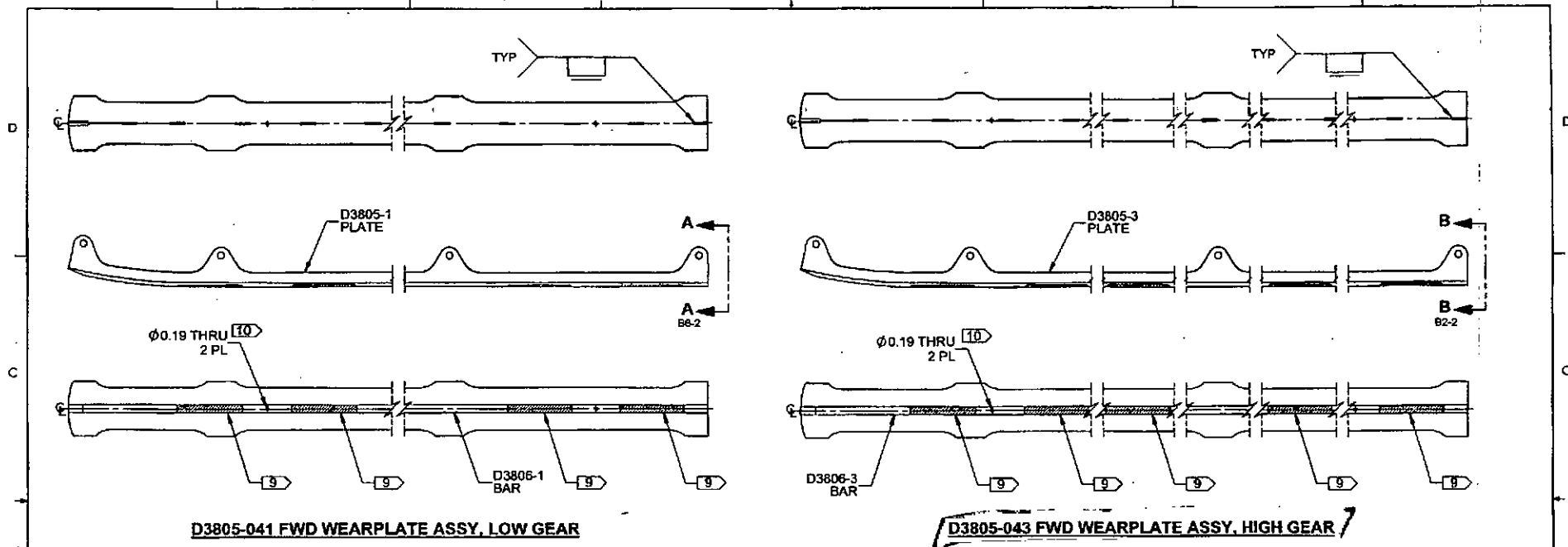
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



RELEASED
2011-10-03

77584

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
- 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	11.09.16	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY REASON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	

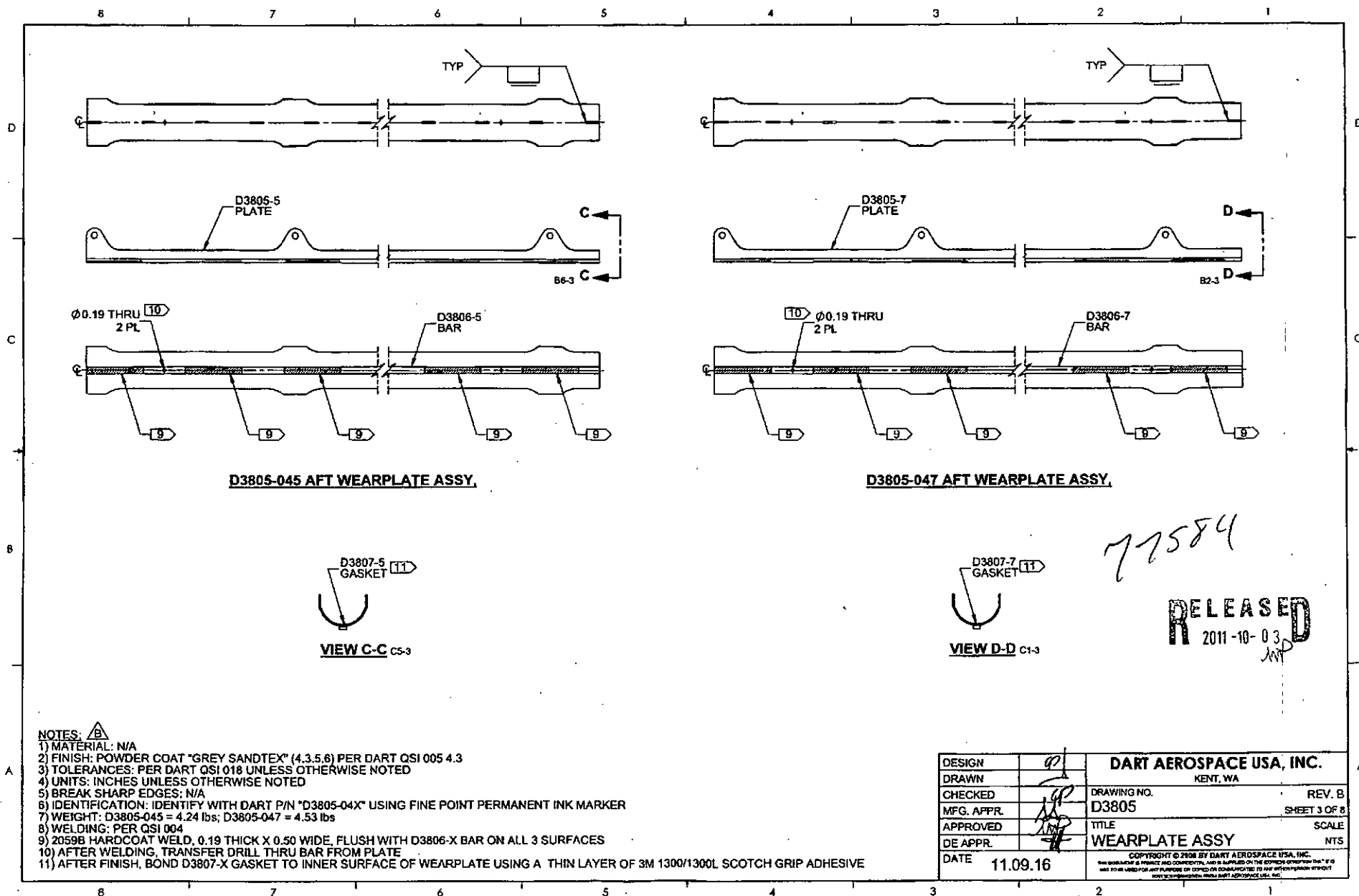
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2011-10-03

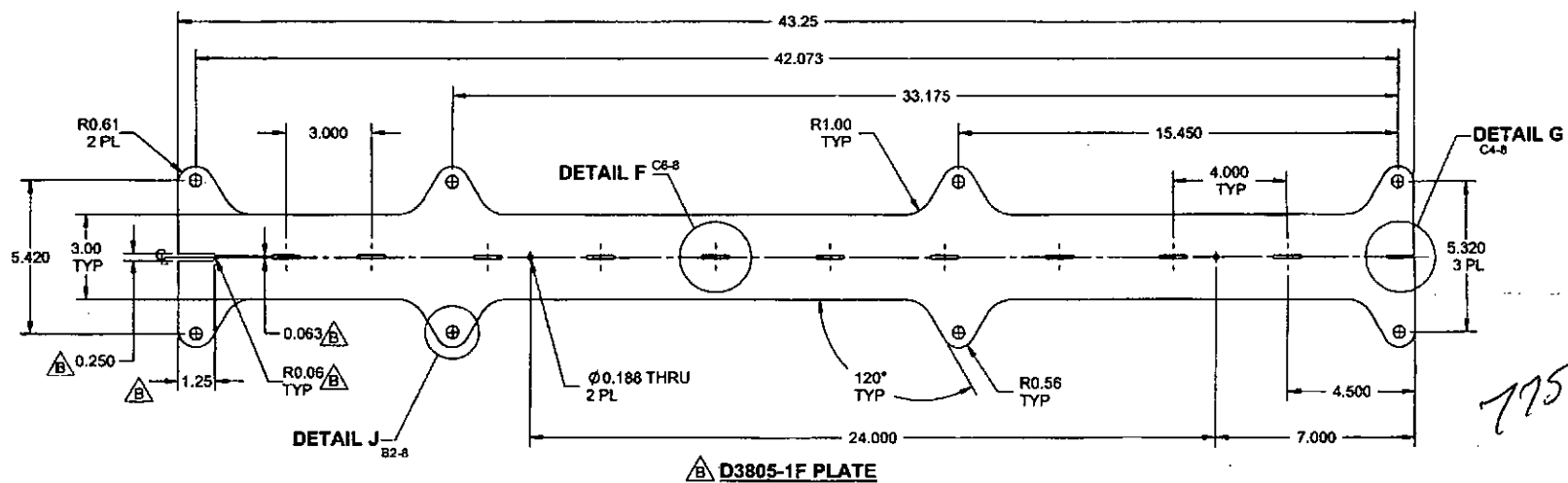
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NOTE: Date & initial all entries



1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 2.11 lbs

DESIGN	97	DART AEROSPACE USA, INC.	
DRAWN	3	KENT, WA	REV. B
CHECKED	9	DRAWING NO.	SHEET 4 OF 6
MFG. APPR.	AK	D3805	
APPROVED	100	TITLE	SCALE
DE APPR.	#	WEARPLATE ASSY	NTS
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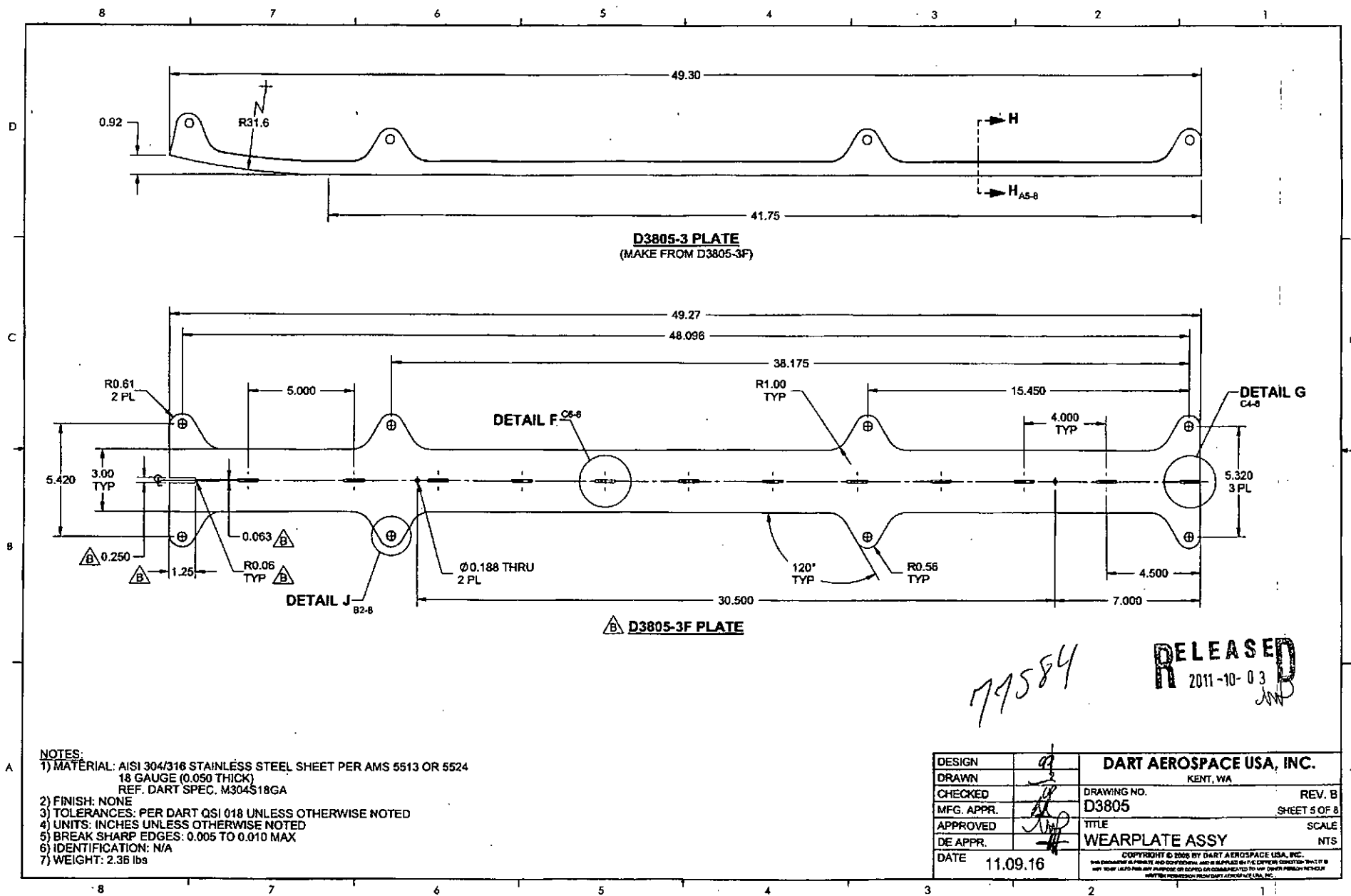
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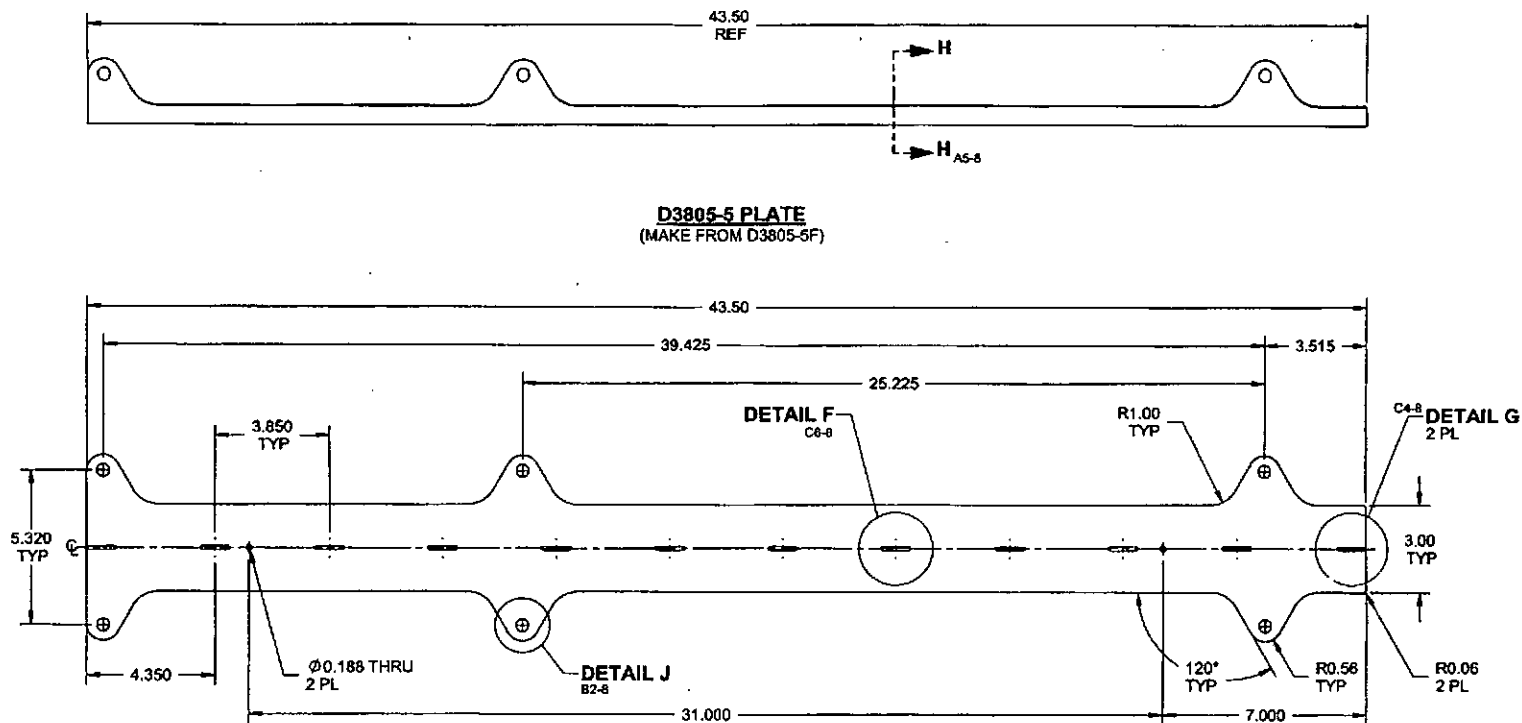
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NOTE: Date & initial all entries



D3805-5 PLATE
(MAKE FROM D3805-5F)

D3805-5F PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

DESIGN	91	DART AEROSPACE USA, INC.	
DRAWN	91	KENT, WA	
CHECKED	91	DRAWING NO.	REV. B
MFG. APPR.	91	D3805	SHEET 8 OF 8
APPROVED	91	TITLE	SCALE
DE APPR.	91	WEARPLATE ASSY	NTS
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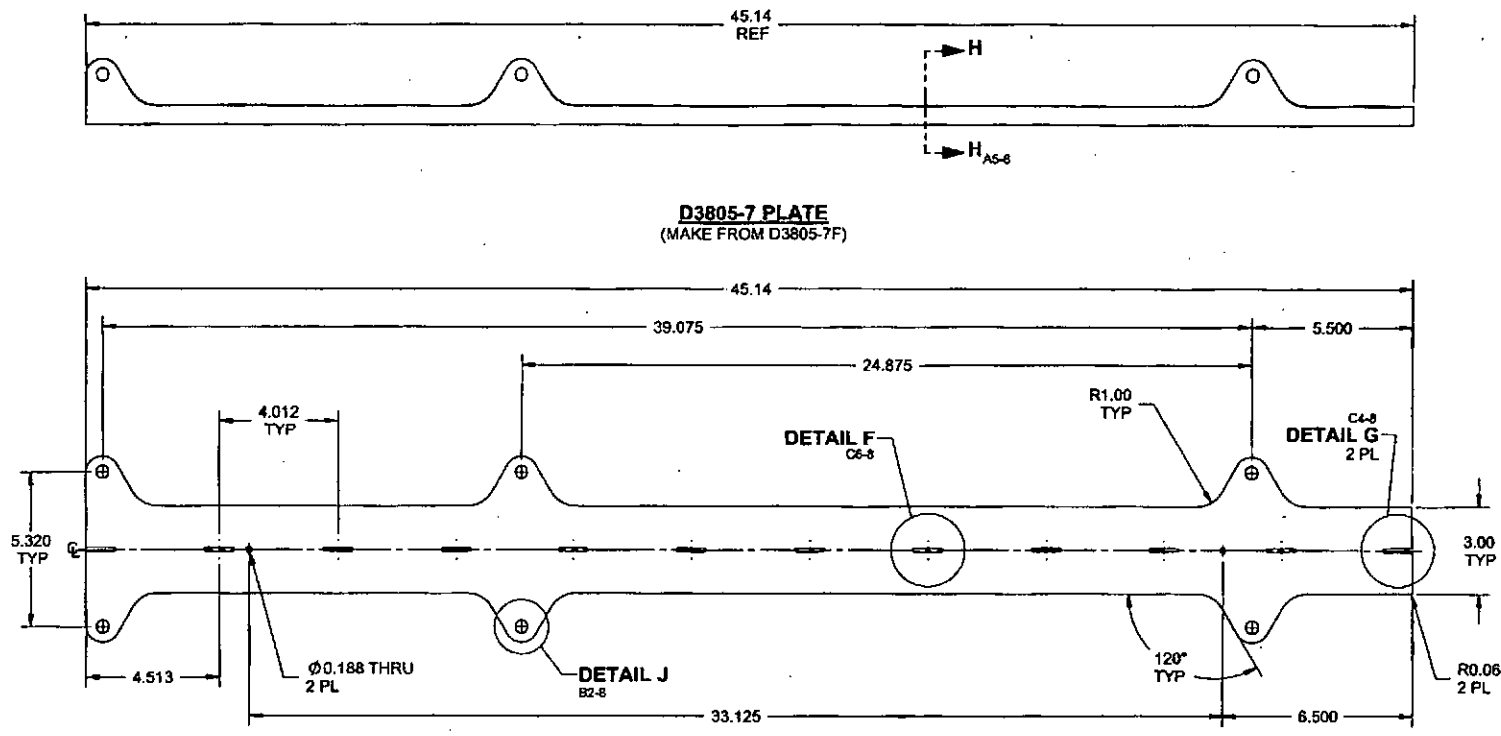
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NOTE: Date & initial all entries



D3805-7 PLATE
(MAKE FROM D3805-7F)

D3805-7F PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE		11.09.16	

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2011-10-03

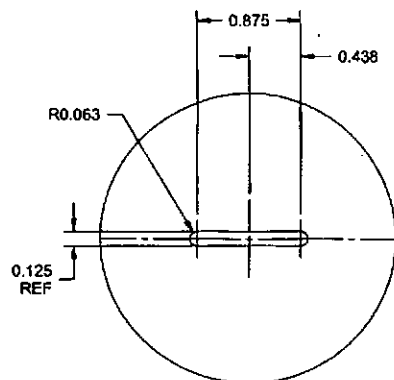
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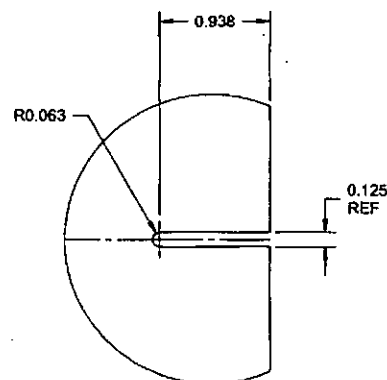
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



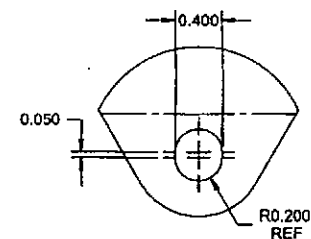
DETAIL F
SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



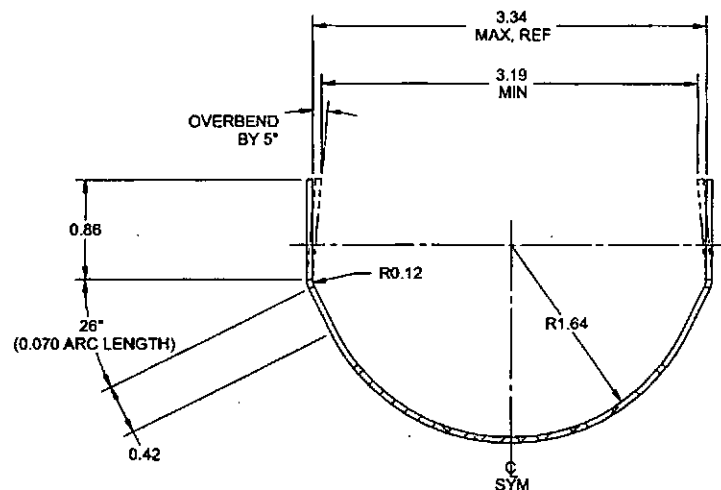
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-6
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-6
B6-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

77584

RELEASED
2011-10-03

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D3805	REV. B
MFG. APPR.		SHEET 8 OF 8	
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries